

# Work Order ID 71535



Page 1

Wednesday, July 06, 2011 11:27:09 AM

Item ID: D4072-1

Revision ID:

Item Name: Airframe Hinge

Start Date: 7/6/2011 Start Qty: 12.00

Required Date: 7/20/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: C2

Date: 11/07/06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4072

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 1.250" LONG

SL 11-07-18

100 d

105

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA938

Dwg Rev: 6

Folio Rev: AA

SL 11-07-21

105 d

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71535**

Wednesday, July 06, 2011 11:27:09 AM



Page 2

Item ID: D4072-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Airframe Hinge

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/07/21

20

0



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

B.A 11/07/21

20

0



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

20 0 JL 11-7-21.



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 71535

Wednesday, July 06, 2011 11:27:09 AM



Page 3

Item ID: D4072-1

Accept



Setup Start



Revision ID:

Item Name: Airframe Hinge

Stop



Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M. 11/7/11 START: 7:50</i> <i>MENT: 3:20</i> <i>FINISH: 7:20</i>	0.00 0.00				20	0	11-7-22	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				20	0	11/04/22	
180  Packaging Packaging	Identify as per dwg & Stock Location <i>120</i>  Memo	0.00 0.00						11/7/22	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 11:27:07 AM

Page 1

Work Order ID: 71535

Parent Item: D4072-1

Parent Item Name: Airframe Hinge



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP  
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS  
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X02.50  
0

Purchased

No

100

f

35.0800

0.104

1.313684



6061-T6 Bar 1.00 x 2.50



SL 11-07-18

Location

Loc Qty

Loc Code

MAT004

35.08

✓ 103019

7.08

103039

8

114993

20

x 185

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71535
<b>Description:</b> air frame hinge		<b>Part Number:</b> D4072-1
<b>Inspection Dwg:</b> D4072	<b>Rev:</b> B	<b>Page 1 of 1</b>

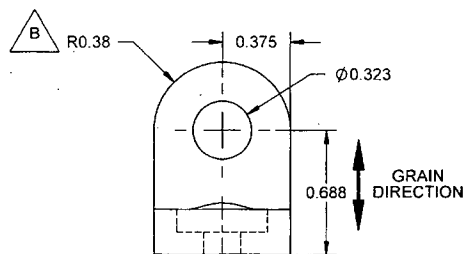
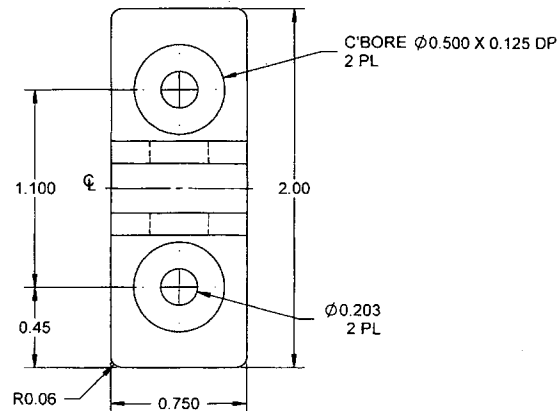
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
500X.125	+ -0.10	501X.125	✓		MAN-JL-3	
2.00	+ -0.030	2.000	✓			
Ø.203	+0.005 -0.01	.204	✓			
.750	+ -0.010	.750	✓			
5.06	+ -0.030	.060	✓		R-G	
.45	+ -0.030	.440	✓			
1.100	+ -0.010	1.100	✓			
5.38	+ -0.030	.375	✓		R-G	
.375	+ -0.010	.375	✓			
.688	+ -0.010	.688	✓			
.275	+ -0.010	.275	✓			
5.13	+ -0.030	.125	✓		R-G	
.25	+ -0.030	.247	✓			
1.06	+ -0.030	1.060	✓			
.125	+ -0.010	.125	✓			
.86	+ -0.030	.870	✓			
.025	+ -0.010	.021	✓			
Ø.323	+0.005 -0.001	.324	✓			

<b>Measured by:</b> SL	<b>Audited by:</b> M.A	<b>Preliminary Approval:</b>
<b>Date:</b> 11-07-20	<b>Date:</b> 11/07/21	<b>Date:</b>

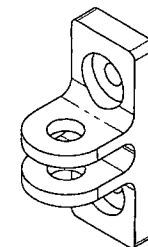
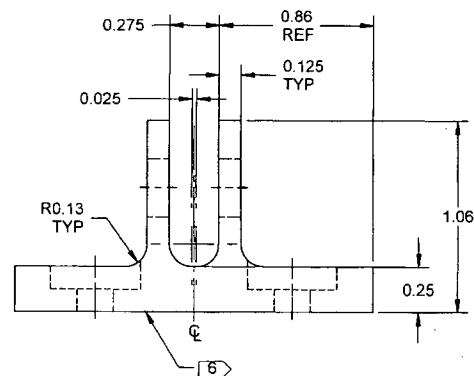
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71535

*CZ11/07/06*



**D4072-1 AIRFRAME HINGE**

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER QSI 044 6.1
  - 7) WEIGHT: 0.04 lbs

**RELEASED**  
2011-06-30  
ANT

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.11.02		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D4072</b> TITLE <b>AIRFRAME HINGE</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			